

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014269**Date Inspected:** 23-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD

Segment # 7AW~ 7BW

This Quality Assurance (QA) Inspector witnessed final tension verification for Lower Chevron Angle (Counter Weight & Cross Beam side) at Panel Point (PP) 48~ 51 and PP 51(Except for PP51 CB Side) Segment 7AW & 7BW. Inspected 100% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00328 Dated April 23, 2010.

Bolt sizes used were M22 x 65 RC Set# DHGM220021 and final torque required was Rotation of Nut 180 degree.

Segment 7EE ~ 8AE ("T"-Rib) Joint Survey

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA Inspector performed Joint Inspection with ABF Survey Team for the T-Rib between Segment 7EE ~ 8AE between Panel Point (PP) 61 and PP 62 North (Bike Path side) and South (Cross Beam side) for Offset. Offset was measured at 1000 mm Straight Edge. The measured readings were recorded on spread sheet, generated the report and submitted to the Task Leader and Engineer for review.

Segment # 7EE-PP60

This QA inspector observed, ZPMC qualified welding personnel identified as 067609 perform Shielded Metal Arc Welding (SMAW), weld joint identified as EP083-001-009; ZPMC QC is identified as Mr. Wang Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2114-FCM-1. See the attached below Photo.

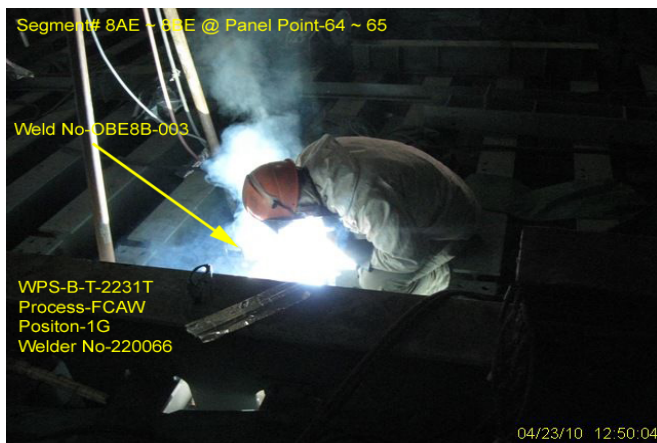
Segment # 8AE-PP61

This QA inspector observed, ZPMC qualified welding personnel identified as 066479 perform Shielded Metal Arc Welding (SMAW), weld joint identified as EP094-001-006; ZPMC QC is identified as Mr. Wang Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2114-FCM-1. See the attached below Photo.

Segment # 8AE~8BE

This QA inspector observed, ZPMC qualified welding personnel identified as 067609 perform Shielded Metal Arc Welding (SMAW), weld joint identified as EP083-001-009; ZPMC QC is identified as Mr. Wang Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2231T. See the attached below Photo.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhune,Manoj	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
